

Date: Monday, 19/01/2009 9:17:10 AM
 User: Linda Lacelle

Process Sheet

Customer : CC-DAR01 Dart Aerospace Ltd.

Job Number : 44883

Estimate Number : 10804

P.O. Number :

This Issue : 19/01/2009 S.O. No. :

Prsht Rev. : NC

First Issue : / / Type : CROSSTUBES

Previous Run : 44882

Written By : Checked & Approved By : 

Comment :

Drawing Name : D206-667-203

Part Number : D206667203

Drawing Number : REWORK-HAI

Project Number :

Drawing Revision :

Material :

Due Date : 26/01/2009 Qty: 1 Um: Each

Additional Product

DART		TEL: 1-613-632-4336	
TRANSPORT CANADA APPROVAL 40839		FAX: 1-613-632-4448	
PN	D206-667-203	CHG	CHG002
DESC	Crosstube Aft High	STC	SH01-5
LOT	B35044	STC	SR01304NY
MODEL	Bell 206L/L1/L3/L4	STC	
MADE IN CANADA			

Job Number:



Seq. #: Machine Or Operation:

Description :

1.0 CROSSTUBES

CROSSTUBES RESOURCE 1



Comment: CROSSTUBES RESOURCE 1

PULL FROM 2008 HAI

1 X D206-667-203 B35044 CHG002

ml 09 01 19

①

2.0 D206667203

Crosstube Aft



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
 Crosstube Fwd

ml 09 01 19

①

3.0 CROSSTUBES

CROSSTUBES RESOURCE 1



Comment: CROSSTUBES RESOURCE 1

REMOVE SUPPORTS, RE-INSTALL WITH Rubbw Cushion: 41108
 MAGNABOND PER CHG003 B109900 clmp: 108187

ml 09 01 21

①

4.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

209.01.22

5.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

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Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

AN534A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Bolt

Batch: M109752

M109752

7.0

MS21042L5

Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Nut

Batch: M109297

8.0

AN510A

Bolt



Comment: Qty.: 10.0000 Each(s)/Unit Total : 10.0000 Each(s)

Pick:Packing Kit

Qty Part number

Description Batch

10 AN5-10A

Bolt M109752

9.0

AN532A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:Packing Kit

Qty Part number

Description Batch

4 AN5-32A

Bolt M110363

10.0

AN960JD516

Washer



Comment: Qty.: 18.0000 Each(s)/Unit Total : 18.0000 Each(s)

Pick:Packing Kit

Qty Part number

Description Batch

18 AN960JD516

Washer M109752

11.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

809/01/22 (10)

Date: Monday, 19/01/2009 9:17:10 AM
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Process Sheet

Customer: CC-DAR01 Dart Aerospace Ltd.

Drawing Name: D206-667-203

Job Number: 44883

Part Number: D206667203

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

PACKAGING 1

PACKAGING RESOURCE #1



②

Comment: PACKAGING RESOURCE #1

REPACKAGE PER PPP

USING NEW B/N

NEW LABELS AND PAPERWORK REQ'D

for J20 09/01/22
CHG003

Rev D 9/1/22 JJS SP

13.0

QC21

FINAL INSPECTION/W/O RELEASE



09/01/26 JJS

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



mf
09-01-23

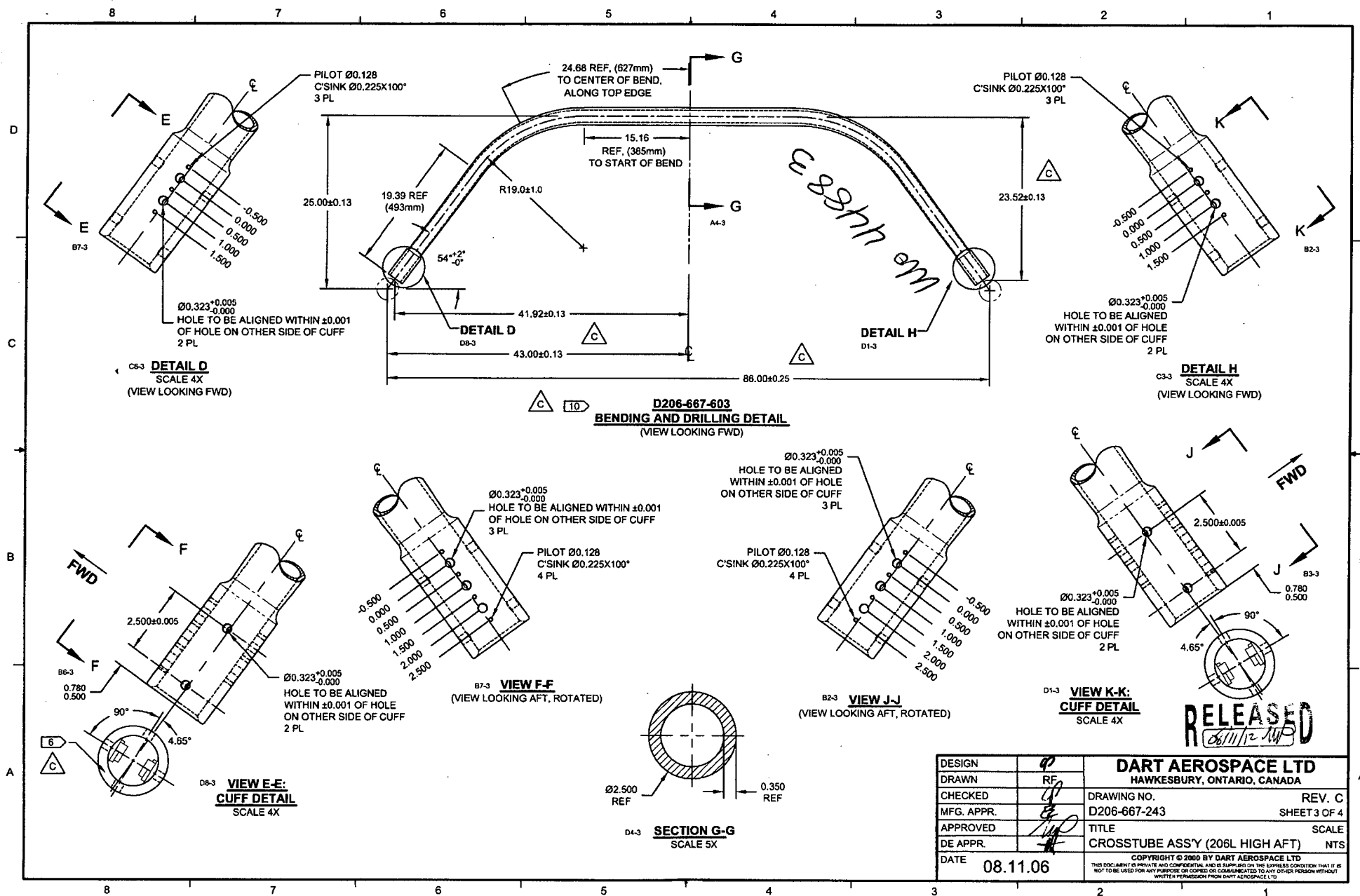
Item	Qty -243	Part Number	Description
1	X	D206-667-243	CROSSTUBE ASSEMBLY (206L HIGH AFT)
2	1	D6004-115	CROSSTUBE
3	2	D2873-043	NUT PLATE
4	2	D2873-045	NUT PLATE
5	2	D2892-1	SUPPORT
6	4	D3595-063-450	RUBBER CUSHION
7	4	MS21920-22	CLAMP
8	14	MS20601AD4W10	RIVET (OR NAS9302B-4-10)
9	A/R	MAGNOBOND 6398	ROCKWELL SPECIFICATION RBO-120-023 ADHESIVE (TEXTRON/BELL SPEC. 299- 947-100, TYPE II, CLASS 2 ADHESIVE)

GENERAL NOTES:

- 1) MATERIAL: MANUFACTURED FROM D6004-115
FINISHED LENGTH = 104.91±0.020
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2
PAINT OUTSIDE PER DART QSI 005 4.2
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED.
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX.
- 6) IDENTIFICATION: SCRIBE DART PART NUMBER "D206-667-243" AND BATCH NUMBER ON
INSIDE OF CUFF USING VIBRATING STYLUS.
- 7) WEIGHT: 21.9 lbs
- 8) PART IS SYMMETRIC ABOUT CENTERLINE.
- 9) RUN CUTTER OFF PART WHERE INDICATED. BLEND OUT EDGE LONGITUDINALLY,
TRANSITION SHOULD BE SMOOTH.
- 10) BEND PROGRESSIVELY WITH A MINIMUM OF 8 PASSES. MAXIMUM TUBE FLATTENING DUE
TO BENDING IS 6% BASED ON O.D.
- 11) LIQUID PENETRANT INSPECT OUTSIDE SURFACE OF CROSSTUBE PER QSI 038.
- 12) INSTALL D2892-1 SUPPORT USING 0.03" TO 0.06" THICK LAYER OF MAGNOBOND 6398 PER
QSI 015. LET CURE FOR 12 HOURS AFTER INSTALLATION AND PRIOR TO PACKAGING.
- 13) INSTALL MS21920-22 CLAMPS WITH D3595-063-450 RUBBER CUSHIONS TO SECURE THE
D2892-1 SUPPORT ON TOP SIDE OF THE CROSSTUBE. ENSURE CLAMP MECHANISMS ARE
LOCATED ON CROSSTUBE SUPPORTS.
- 14) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE
OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS
SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT
LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.
- 15) TORQUE CLAMPS 80 TO 100 IN-LB. ENSURE AT LEAST 1.5 THREADS ARE SHOWING IN
SAFETY AND THAT NUT HAS NOT BOTTOMED-OUT AFTER TORQUING.

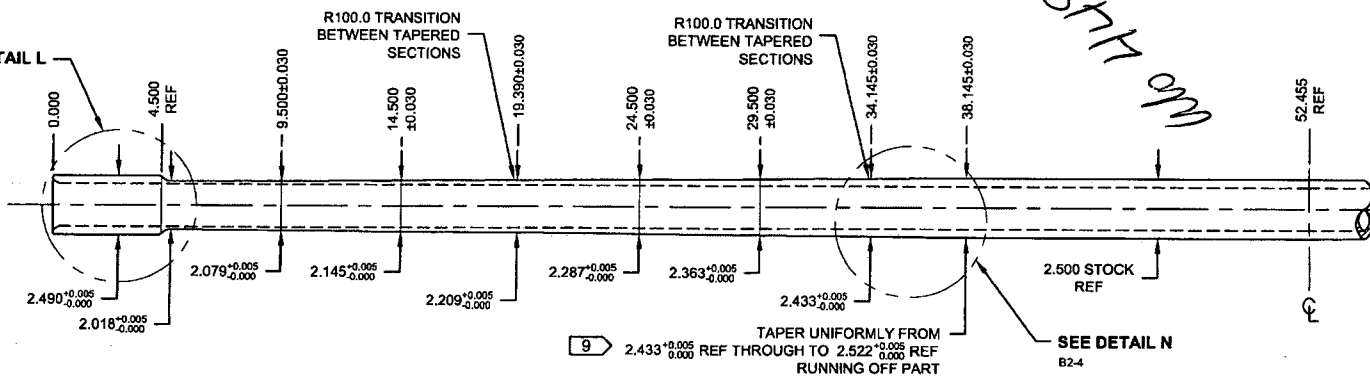
RELEASED
06/11/17

C	REVISE GENERAL NOTES/PART LIST (ZN D7-1); REORGANIZED VIEWS AND REFORMATTED DRAWING TO CURRENT STANDARDS. D3595-063-450 WAS D2856-400-773 (ZN D6-2 & A5-2); REMOVED REF. & ADD TOLERANCES (ZN 4-3, CS-3, D3-3); RELOCATED FLAG #6 (ZN A8-3) PER NCR 210; MOVED TURNING DETAIL & UPDATED TOLERANCE TO SHEET 4.	RF	08.11.06
B	ADD HOLES AND NUT PLATES FOR COMPATABILITY WITH BHT/AA SKUDTUBES	PH	05.07.26
A	NEW ISSUE	CP	00.11.17
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF	DRAWING NO.	REV. C
CHECKED	RF	D206-667-243	SHEET 1 OF 4
MFG. APPR.	RF	TITLE	SCALE
APPROVED	RF	CROSSTUBE ASSY (206L HIGH AFT)	NTS
DE APPR.	RF	COPYRIGHT © 2000 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DATE	08.11.06		

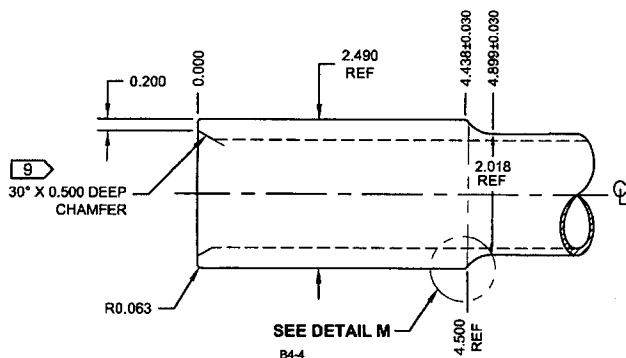


DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	RF	DRAWING NO. D206-667-243	REV. C
MFG. APPR.	RF		SHEET 3 OF 4
APPROVED	RF	TITLE CROSSTUBE ASS'Y (206L HIGH AFT)	SCALE
DE APPR.	RF		NTS
DATE	08.11.06	<small>COPYRIGHT © 2000 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	

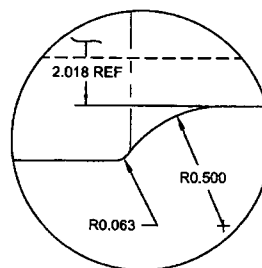
SEE DETAIL L
B7-4



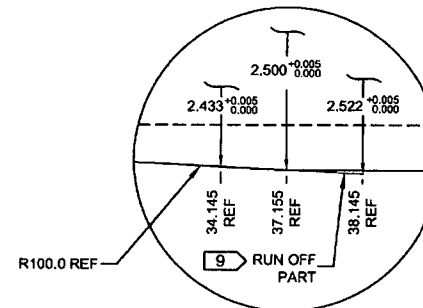
TURNING DETAIL



DETAIL L: CROSSTUBE CUFF
NOT TO SCALE



DETAIL M: CUFF TRANSITION
NOT TO SCALE



DETAIL N: TAPER RUN-OFF
NOT TO SCALE

RELEASED
08/11/12

DESIGN	90	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	RF	DRAWING NO.	REV. C
MFG. APPR.	RF	D206-667-243	SHEET 4 OF 4
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	CROSSTUBE ASSY (206L HIGH AFT)	NTS
DATE	08.11.06	<small>COPYRIGHT © 2000 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	